



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D3492-1

Job Sheet 186750



Part No: D3492-1

Job Qty: 80 ea

Part Name: Plug



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/21/18

Job Tracking No:

Due Date: 12/3/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV E IPP Rev:A 11.04.19 per dwg revC DD verf:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	80 Ea	12/3/18	12/3/18	0.00	0.00	Start Up Machining-2		JSD 12/12/17
100	Hardinge	80 pcs	12/3/18	12/3/18	0.00	2.45	Hardinge		" "
120	QC	80 pcs	12/3/18	12/3/18	0.00	0.00	QC8		2.18/12/19
150	HandFinish	80 pcs	12/3/18	12/3/18	0.00	0.26	HandFinish1		D.R. 12/11/19
155	Outsource	80 pcs	12/3/18	12/3/18	0.00	0.00	Outsource11		
160	Powdercoat	80 pcs	12/3/18	12/3/18	0.00	0.13	Powdercoat1		B.L. 8/12/19
165	Packaging	80 pcs	12/3/18	12/3/18	0.00	0.00			U/R
170	QC	80 pcs	12/3/18	12/3/18	0.00	0.00	QC3		12-12-20
180	Packaging	80 pcs	12/3/18	12/3/18	0.00	0.00	Packaging3-1	FP-001	12-12-22
190	QC21-SA	80 Ea	12/3/18	12/3/18	0.00	0.00	QC21		21 DEC 20 2018

Part Op 100 - 1-Turn as per Folio FA633 & Dwg D3492 Dwg Rev:

Descriptions: 160 - (Flat End Only) START TIME: 3:15 FINISH TIME: 3:45 O.I.T: 820 11/13/15

180 - LOCATION : FP001

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6R0.625	6061-T6 Round Bar .625"	4.2400 ft (.053 ea)	90-Start up Operation	5090365

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6R0.625	4	36	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Plug	0.060inches $\pm$ 0.005	0.065 0.055		
2	Plug	0.060inches $\pm$ 0.005	0.065 0.055		
3	Plug	0.394inches $\pm$ 0.010	0.404 0.384		
4	Plug	0.625inches $\pm$ 0.010	0.635 0.615		

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER :					

5	Plug	0.090inches + 0.000 - 0.002	0.090 0.088
6	Plug	0.500inches ± 0.010	0.510 0.490
7	Plug	0.050inches + 0.000 - 0.002	0.050 0.048
8	Plug	0.050inches ± 0.010	0.060 0.040
9	Plug	20.000Degrees ± 0.000	20.000 20.000

Plex 11/21/18 8:43 AM Dart.lajeunesse.marie

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

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